- SS 304 TRO.500" w.049

Work Orde				*754	183*							Page 1
Item ID: Revision ID: Item Name:	D3286-3 Spacer			Accept	*N900	<u> </u>	100	)*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	24/10/2011 15/11/2011	Start Qty: 80.00 Req'd Qty: 80.00			Cust Item Customer:							. 12
Approvals:	Process Pla	an: MLJ	Date: IIII O 24	Tooling: SPC (Y/N):		Pate:				Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr					. :					
D3286	Rev	/ A										
100 <b>*1</b> Hardinge		Hardinge CNC LATH	E SMALL	0.00				80	Ø			LL 11/11/0
Hardinge CNC Lath	ne Small	Turn blan	ks as per Folio FA434 and Dv [per Dwg D3286	vg D3286								
*110 *110*		QC2- Inspect parts off	machine FAI/FAIB	0.00				80	b			If while
QC Quality Control	. ,	Memo		0.00					_ <i>_F</i> _		·	
120		QC8- Inspect parts - se	econd check	0.00	1 1				••			
*120* QC		Memo		0.00	1 A. B.	20		80	•	4_		· 

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W/O:			WC	ORK ORDER CH	ANGES					
DATE	STEP	PROC	EDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mar	Approval QC Inspector
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							-			
Part No	•	PAR #:	_ Fault Cate	gory:	NCI	R: Yes N	lo DQ	<b>\</b> :	Date:	
	Re	esolution:	_ Dispositio	n:	QA	N/C Clo	sed:		Date: _	
NCR:		. <b>W</b>	ORK ORD	ER NON-CONFO	RMANCE	(NCR)	)		,., <u>.</u>	
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Descrip	otion 	Sign & Date	Section	on C	Chief Eng	QC Inspector
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	1					+				[

Work Order ID 75483 \*75483\* Page 2 October-24-11 10:22:01 AM Item ID: D3286-3 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Spacer **Start Qty: 80.00** \*80\* **Start Date:** 24/10/2011 **Cust Item ID: Required Date: 15/11/2011** Req'd Qty: 80.00 \*80\* **Customer:** Reference: Run Process Plan: Date: **Approvals: Tooling:** Date: Date: SPC (Y/N): Date: Sequence ID/ Tool ID Tool # Plan Reject Operation Set Up/ Accept Reject Insp. **Description Work Center ID** Run Hours Code Qty Number Stamp Oty Identify as per dwg & Stock Location: 130 \*130\* Packaging 0.00 Memo Packaging \*\*\*STOCK IN SKIDTUBE CELL\*\*\* 140 QC21- Final Inspection - Work Order Release 0.00 \*140\* 0.00 Memo

Quality Control

MF 11-11-03

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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Mgr	
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							<u> </u>		
Part No:	<u> </u>	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	<b>4:</b>	_ Date: _	·
	R	esolution:	Disposition	n:	_ QA: N/C Cld	sed:		Date: _	
NCR:				ER NON-CONFORMA					
DATE	CTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
	,								
								1	

**Picklist Print** October-24-11 10:22:06 AM Work Order ID: 75483 \*75483\* \*D3286-3\* Parent Item: D3286-3 Parent Item Name: Spacer Required Date: 15/11/2011 Start Date: 24/10/2011 **Start Qty: 80.00** Required Qty: 80.00 Comments: IPP A04.07.14New issueKJ/JLM Component Item ID/ Primary Qty per Kit Total Replacement Mfg/ Bin Last Route Unit of Qty on Qty Date Item Name Measure Hand Item ID Item Location Location Seq ID Purch Issued Qty Issued M304TR0.500W.049 Purchased No 110 f 348.5211 0.3417 28.77474 \*M304TR0 500W 049\* \*\* 8.000 304 RD Tube .500 x .049W

> Location Loc Qty Loc Code MAT017 348.521058 111814 2.23 115010 145.421058 117598\_ 49.87 28.000 119087 151

Page 1

Status

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W/O:			WORK ORDER	CHANGES	<del></del>	· <del></del>		
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						,		
Part No	:	PAR #:	Fault Category:	NCR: Yes	s No DQ	A:	Date: _	
	Resolution:		Disposition:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDER NON-CON	IFORMANCE (NO	R)			
			Corrective Actio	n Castian B				

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annroyal	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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DART AEROSPACE LTD	Work Order:	75483
Description: Spacer	Part Number:	D3286-3
Inspection Dwg: D3286 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

		First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		Comments
4.000	+/-0.010	3.999			51.08		
0.500	+/-0.010	0.500			SL08		
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	11					<del></del>	
Measured by:	11	Audited by:	D.A		Prototype		N/A
Date:	1/11/02	Date:	11/11/07	2		Date:	N/A
Rev Date	Change					Revised b	y Approved
	New Issue					KJ/JLM cx	

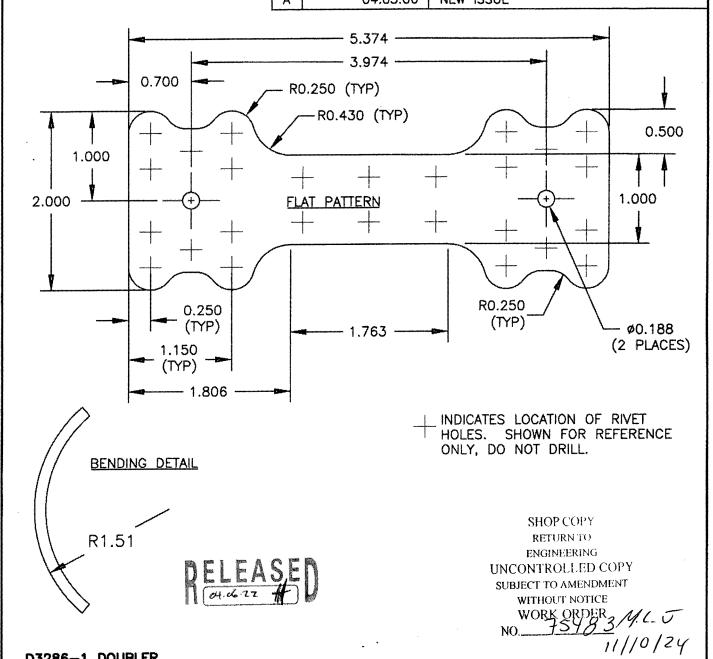
## **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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-									
Part No	•	PAR #:	Fault Categ	ory:	NCR: Ye	s No DC	A:	Date: _	<u> </u>
	Res	olution:	Disposition	:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NO	R)	•		
DATE	STEP	Description of NC			tion B	Verif	ication	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		tion C	Chief Eng	QC Inspector
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DESIGN (P	DRAWN BY	DART AEROSPACE	
CHECKED,	APPROVED	DRAWING NO.	REV. A
#	#r	D3286	SHEET 1 OF 2
DATE		TIME .	SCALE
04.05.06		GROUND HANDLING PARTS	1:1
Δ	04.05.06	NEW ISSUE	



D3286-1 DOUBLER

1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK (REF DART SPEC. M304S11GA)

- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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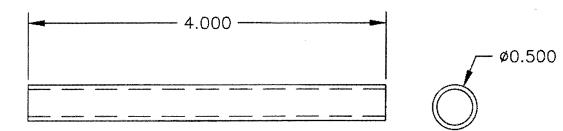
## **Dart Aerospace Ltd**

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W/O:			WO	RK ORDER CHANG	ES		· · · · · · · · · · · · · · · · · · ·				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Cate	jory:	NCR: Yes No DQA: Date:						
Resolution:			Disposition: Q/			osed:	Date:				
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NCF	)					
DATE	STEP	Description of NC	Corrective Action Section Initial Action Description				ication Approval				
	Section A	Chief Eng	Chief Eng	Date	Secti	ion C	Chief Eng	QC Inspector			
					740.00						





DESIGN	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V		IC.	*******
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1 4	<b>₩</b>	D3286		SHEET	2 OF	2
DATE		TITLE			SCA	LE
04.05.06		GROUND I	HANDLING PARTS	8	1	1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES



## **Dart Aerospace Ltd**

W/O:	•		W	ORK ORDER CHANG	ES					
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